



Graphics  
Labor  
Parts  
Parts Exchange  
Pricing

# 2008-2009 Database Reference Manual

**Audatex Estimating™**  
**PenPro®**  
**Shoplinc®**

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# Two-Stage

## Included Operations:

- Move car
- Review estimate/work order
- Get paint code
- Order paint
- Get paint
- Gather materials, equipment and tools\*\*
- Clean equipment and materials
- De-wax and degrease
- Prepare to sand
- Dual action sand\*
- Hand/wet sand
- Mix, apply, and flash primer (for adhesion and sealing)
- Application of guide coat\*
- Block sand\*
- Weld-thru primer\*
- Water wash and clean panel with solvent
- Blow dry clean panels
- Prepare to spray
- Clean booth
- Booth operations
- Protect exterior of vehicle from overspray **including the gap between panels** (e.g., all acceptable methods of bagging, masking, masking up to 36 inches surrounding the panel, masking of glass within a panel, **backtaping and foam tape**)
- Basic corrosion protection provided by paint system/primer **applied**
- Mix and apply flash; additives
- Tack wipe
- Mix color, spray test panel, compare to vehicle
- Initial tint, spray test panel, let down, compare to vehicle\*\*
- Apply and flash; color
- Inspect job and paint
- Clean gun; color
- Add flex additive\*\* (if required)
- Tack wipe (between color and clear if required)
- Apply flash clear coat
- Clean gun; clear\*\*
- Mix clear coat\*\*

\* Welded panel operations

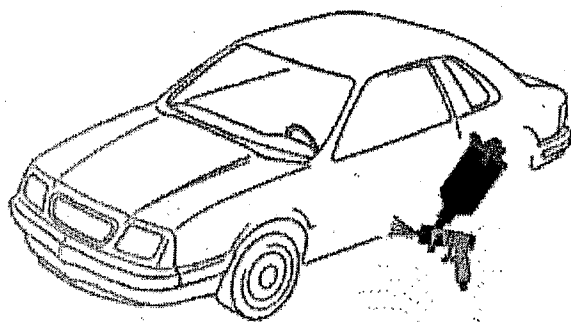
\*\* Included in setup

Also see:

Blending Formula

## NOT Included:

- Body work
- Spot putty
- Panel stripping
- Additional preparation or cleaning of new, unprimed panels (i.e., bumper covers)
- Removal of release agents from raw, unprimed plastic components (i.e., bumper covers)
- Moulding R&I
- Stripe R&I
- Parts R&I
- Painting of stripes
- Adhesive removal
- Protect interior surface and jambs
- Mask mouldings
- Spray additional test panel
- Blending into adjacent panels
- Final Sand, Polish and Buff
- Chipguard application
- Gravel guard (see Chipguard )
- Additional time for two-tone
- Additional time for three-stage
- Custom finishes
- Tint primer or clear coat
- Undercoating
- Metal preparation and corrosion protection beyond those listed in Included Operations (i.e., **cavity wax**)
- Final wash
- Hazardous waste removal
- Any special coatings applied to luggage compartment
- Second or third bagging or masking of vehicle
- Paint and materials



*Footnotes found in a chapter contain vehicle-specific information. The content of footnotes is in addition to, and takes precedence over, information in the Guide to Estimating pages for the operation indicated.*

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### BASIC COLOR COAT APPLICATION

#### **INCLUDED:**

- Back tape opening (handle, lock cylinder, mirror)
- Clean component (solvent wash)
- Clean sprayer
- Color coat application
- Initial dry sand (from 180 grit sandpaper)
- Light buff; Lacquer paint only
- Load sprayer
- Mask adjacent panels (3 foot perimeter)
- Mask / close gap between adjacent panels up to foam tape (over spray)
- Mask glass opening
- Mask / protect grille radiator opening (over spray)
- Mix paint
- Primer-Sealer coat application
- Primer-Sealer coat final clean
- Primer-Sealer coat final application
- Remove masking
- Retrieve accurate color information, including paint chip

#### **DOES NOT INCLUDE:**

- Adhesion promoter (unprimed flexible component)
- Backside refinishing
- Blending into adjacent panels
- Color matching to adjacent panels
- Cover mask engine / compartment to prevent overspray
- Cover / mask entire exterior of vehicle to prevent overspray damage
- Cover / mask for prime and block
- Cover / mask for cut-in
- Cover / mask recessed edges / jambs / weatherstrips
- Cover mask trunk / compartment to prevent overspray
- Cover / mask interior of vehicle to prevent overspray damage
- Edge refinishing
- Grind, fill & smooth welded seams (up to 150 grit sandpaper)
- Paint or material costs
- Prime & block (high build / primer-filler)
- Reproduction of non-OEM finishes
- Reproduction of defective OEM textures
- Test spray-out panel
- Tinting Primer Sealer
- Tinting to achieve color match
- Underside refinishing
- Weld, grind or sanding damage to adjacent panels
- Wet sanding

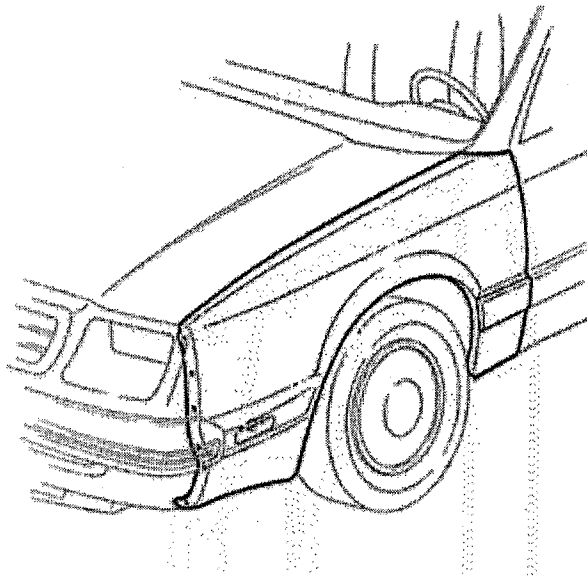
## FENDER - OUTER PANEL

### *INCLUDED:*

- Align to vehicle
- Fillers (if mounted to fender)
- Cornering lamps (if mounted to fender)
- Fender liner
- Scoop
- Side marker
- Side repeater lamp

### *DOES NOT INCLUDE:*

- Antenna
- Bumper R&I
- Battery
- Emblems & nameplates
- Grille
- Header panel
- Hood
- Inner panels
- Lamp aiming
- Mirror
- Moldings
- Mud guard
- Road wheel
- Spoilers & flares
- Stripe tape, decals or overlays



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